



7367

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400213-7
Job Sheet 187461



Part No: RBT400213-7

Job Qty: 3 ea

Part Name: Top Tab Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/18

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400213 Rev F IPP Rev A 17.11.27 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev.
F DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	3 pcs	1/18/19	1/18/19	0.00	3.00	Small Fab-9		MCC DAS
120	QC	3 pcs	1/18/19	1/18/19	0.00	0.00	QC5		DAS 38
130	Packaging	3 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3		28 9-89
140	QC21-SA	3 Ea	1/18/19	1/18/19	0.00	0.00	QC21		9-89

Part Op 110 - -Assemble as per DWG. Sheet 6 --LOCTITE CLEAR EPOXY M 13 8855 EXP: 04/23/2019 Cure time
Descriptions: 8Hrs. Start Time: 1:00 pm Finish Time: 2:30 pm

21
9-89

JAN 09 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-10A	Bolt	20-12 Ea (4 ea)	90-Start up Operation	5082908
RBT400213-3	Left Clamp	3 Ea (1 ea)	90-Start up Operation	5107513
RBT400213-4	Right Clamp	3 Ea (1 ea)	90-Start up Operation	5107340
RBT400213-5	Top Tab	3 Ea (1 ea)	90-Start up Operation	5119232
MS20426AD4-8	Rivet	20-12 Ea (4 ea)	90-Start up Operation	5181364

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-10A	12	103	0
	MS20426AD4-8	12	2,371	0
	RBT400213-3	3	19	0
	RBT400213-4	3	19	0
	RBT400213-5	3	15	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S142740



Part: RBT400213-7

Job No: 187461

Serial No/Batch: S142740

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 01/08/19

Plex 12/5/18 9:30 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



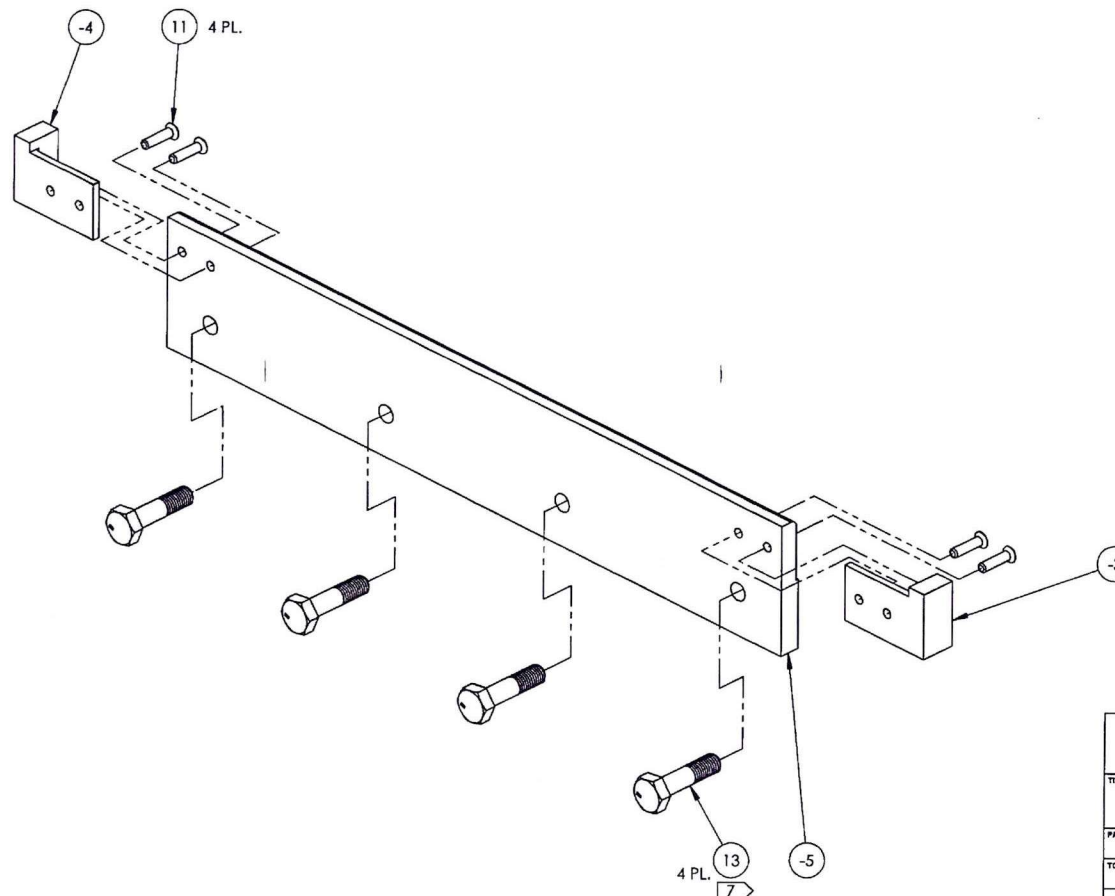
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-3	1	RBT400213-3	LEFT CLAMP	4	F	TEMPLATE UPDATED, EPOXY CHANGED FOR EPOXY DP460	17-797	17.12.21	VM	ML
-4	1	RBT400213-4	RIGHT CLAMP	5						
-5	1	RBT400213-5	TOP TAB	6						
11	4	AN428AD-4-8	C.S HEAD RIVET 1/8" x 1/2" x 100"	-						
13	4	AN4-10A	HEX HEAD BOLT 1/4"-28 x 1 1/32"	-						



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 187461 MJS
18-12-05

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) APPLY SCOTCH WELD DP460 EPOXY UNDER BOLT HEAD AND INSTALL BOLT INTO ITEM -5. ALLOW TO CURE PER MANUFACTURER'S INSTRUCTIONS

RBT400213-7 TOP TAB ASSY

DART AEROSPACE Newmarket, Ontario, Canada	
TITLE TOP TAB ASSY	
PART NO. RBT400213-7	REV F
TOOL NO. RBT400213	INITIALS AND DATE
DESIGNED BY: VM 12/21/2017	TOLERANCES: X .003 FRACTIONS ± 1/8
DRAWN BY: VM 01/02/2018	XX ± .01 ANGLES ± .5°
CHECKED BY: VM 01/02/2018	X ± .1 SURFACE
MFG REVIEW BY: DD 01/02/2018	ROUGHNESS
APPROVED BY: ML 01/30/2018	SCALE: NTS SHEET 3 OF 7
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